

Work Order ID 77272

December-01-11 7:27:30 AM

77272

Page 1

Item ID: D412-630-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per IIN D412-630

ensure tension to retract step is 11 to 18 lbs before installing lockwire.

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

ensure tension to retract step is 11 to 18 lbs *

11-12-02 ①
JG MLJ 11-12-1

EB 11/12/01 ①

11-12-01 ①

Work Order ID 77272

December-01-11 7:27:30 AM

77272

Page 2

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Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

150

Packaging

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: 31
PPP Rev: 5

Work Order ID 77272

December-01-11 7:27:30 AM

77272

Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/06/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

11/12/15
12-11-12-02
(1)

Picklist Print

December-01-11 7:27:28 AM

Page 1

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 NUT		Purchased	No			130	Each	50.0000	1	1	-		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		50							
				118983		13			118983				
				119328		22							
				119799		15							
AN310-5 NUT		Purchased	No			130	Each	30.0000	2	2	-		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		30							
				118112		30			118112				
AN3C5A Bolt		Purchased	No			130	Each	1,291.0000	3	3	-		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP		7							
				115835		7							
				ST350		1284							
				116419		28							
				117343		17							
				117764		52			117764				
				117872		2							
				118451		185							
				119127		500							
				119749		500							

Picklist Print

December-01-11 7:27:29 AM

Page 2

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step. LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

AN44-C12 Purchased No

130 Each 13.0000

1 1

eyebolt

Location

Loc Qty

Loc Code

ST362

13

117616

9

119673

4

117616

AN4C15 Purchased No

130 Each 22.0000

1 1

BOLT

Location

Loc Qty

Loc Code

ST358

22

118652

12

119531

10

118652

AN5C11 Purchased No

130 Each 19.0000

1 1

BOLT

Location

Loc Qty

Loc Code

ST337

19

114801

19

114801

AN5C15 Purchased No

130 Each 13.0000

1 1

BOLT

Location

Loc Qty

Loc Code

ST338

13

117616

13

117616

AN960C516 Purchased No

130 Each 17.0000

1 1

WASHER

Location

Loc Qty

Loc Code

ST337A

17

102842

17

102842

D3454-1 Manufactured No

130 Each 26.0000

1 1

Bushing

Location

Loc Qty

Loc Code

ST054

26

58555

6

74730

20

58555

December-01-11 7:27:29 AM

Shop Packet Print

Page 2

Picklist Print

December-01-11 7:27:29 AM

Page 3

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

D3454-3
Bushing

Manufactured No

130 Each 22.0000 2 2

Location

Loc Qty

Loc Code

ST054

22

68467

2

73348

20

68467 22
~~92348 19~~

h

D3454-5
Bushing

Manufactured No

130 Each 24.0000 2 2

Location

Loc Qty

Loc Code

ST054

24

70527

4

73343

20

70527

h

D3455-1
Spacer

Manufactured No

130 Each 35.0000 4 4

Location

Loc Qty

Loc Code

ST054

35

73302

35

73302

h

D3455-3
Spacer

Manufactured No

130 Each 16.0000 2 2

Location

Loc Qty

Loc Code

ST054

16

68470

1

72163

15

72163

h

D3462-041
Bracket Assembly

Manufactured No

130 Each 1.0000 1 1

Location

Loc Qty

Loc Code

ST198A

1

72030

1

72030

h 11/12/01

December-01-11 7:27:29 AM

Shop Packet Print

Page 3

Picklist Print

December-01-11 7:27:29 AM

Page 4

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

MS21043-3 Purchased No

130 Each 883.0000 3 3

Nut

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	811	
118077	1	
118614	449	
118686	131	118686
119758	230	

MS24665-227 Purchased No

130 Each 81.0000 2 2

COTTER PIN

Location	Loc Qty	Loc Code
GA	81	
111041	81	111041

MS24665-229 Purchased No

130 Each 295.0000 2 2

COTTER PIN

Location	Loc Qty	Loc Code
GA	193	
118234	193	118234
ST309	102	
111041	102	

NAS1149C0363R Purchased No

130 Each 3,810.0000 7 7

Washer

Location	Loc Qty	Loc Code
ST297	3810	
114742	3810	114742

December-01-11 7:27:29 AM

Shop Packet Print

Page 4

Picklist Print

December-01-11 7:27:29 AM

Page 5

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

NAS1515H5 Purchased No

130 Each 148.0000 1 1

Washer

Location	Loc Qty	Loc Code
FG	40	
103286	20	
103691	20	
ST277	108	
103286	100	
118384	8	

D3463-041 Manufactured No

110 Each 1.0000 1 1

Step Weldment Assembly

Location	Loc Qty	Loc Code
ST494	1	
72201	1	

D3443-043 Manufactured No

110 Each 1.0000 1 1

Strut Weldment Assembly

Location	Loc Qty	Loc Code
ST198A	1	
70525	1	

D3443-041 Manufactured No

110 Each 4.0000 1 1

Strut Weldment Assembly

Location	Loc Qty	Loc Code
ST198A	4	
72027	4	

D3443-9 Manufactured No

110 Each 10.0000 2 2

Pin

Location	Loc Qty	Loc Code
ST054	10	
72029	2	
74699	8	

December-01-11 7:27:29 AM

Shop Packet Print

Page 5

Picklist Print

December-01-11 7:27:29 AM

Page 6

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

D3454-7
Bushing

Manufactured No

110 Each 24.0000 2 2

EPB 11/12/01

Location	Loc Qty	Loc Code
ST054	20	
73346	20	
ST058	4	
70528	4	

D3455-1
Spacer

Manufactured No

110 Each 35.0000 2 2

EPB 11/12/01

Location	Loc Qty	Loc Code
ST054	35	
73302	35	

D3465-1
Washer

Manufactured No

110 Each 24.0000 1 1

EPB 11/12/01

Location	Loc Qty	Loc Code
ST054	24	
46134	4	
73449	20	

AN4CH3
SS Bolt

Purchased No

110 Each 34.0000 2 2

EPB 11/12/01

Location	Loc Qty	Loc Code
ST357	34	
117616	1	
118131	3	
118757	10	
118758	20	

AN4C14
BOLT

Purchased No

110 Each 25.0000 1 1

EPB 11/12/01

Location	Loc Qty	Loc Code
ST357	25	
117688	25	

December-01-11 7:27:29 AM

Shop Packet Print

Page 6

Picklist Print

December-01-11 7:27:29 AM

Page 7

Work Order ID: 77272

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 12/01/11

Required Date: 12/06/11

Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No

110 Each 50.0000

1 1

EPB 11/12/01

Location

Loc Qty

Loc Code

ST344

50

118983

13

119328

22

119799

15

AN310-7 Purchased No

110 Each 37.0000

1 1

EPB 11/12/01

Location

Loc Qty

Loc Code

ST344

37

114784

27

119749

10

MS24665-227 Purchased No

110 Each 81.0000

1 1

EPB 11/12/01

Location

Loc Qty

Loc Code

GA

81

111041

81

MS24665-302 Purchased No

110 Each 82.0000

1 1

EPB 11/12/01

Location

Loc Qty

Loc Code

ST357

82

117460

82

December-01-11 7:27:30 AM

Shop Packet Print

Page 7

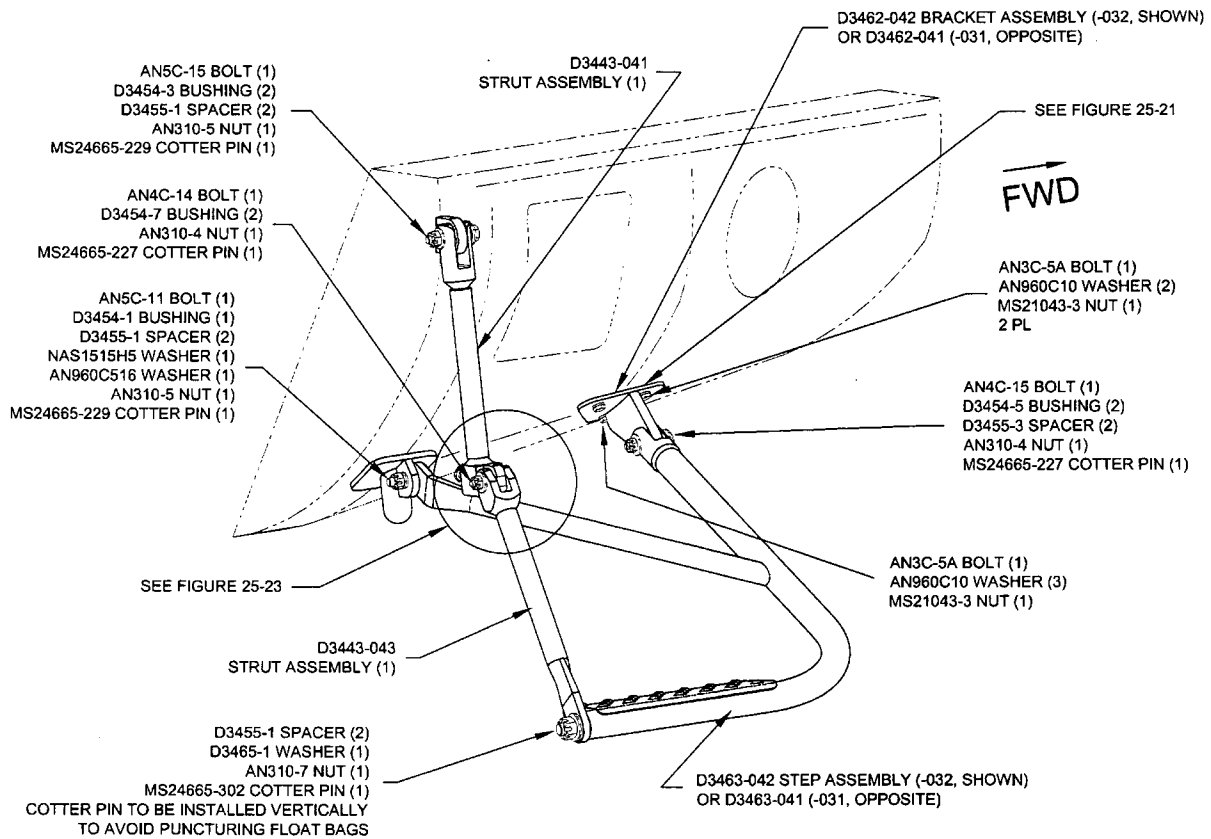


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

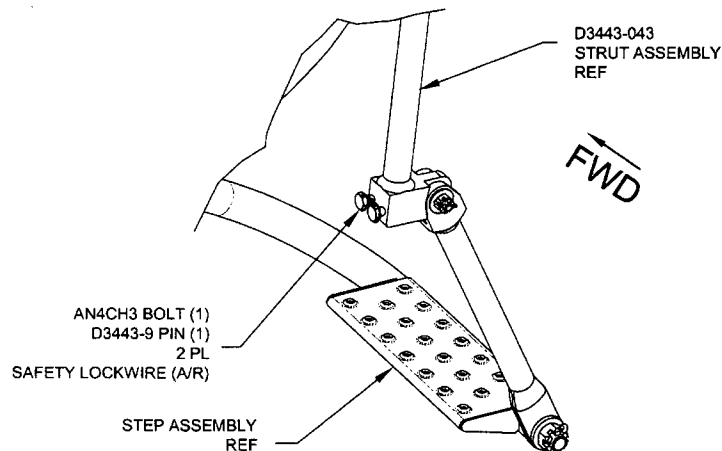


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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